

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019676**Date Inspected:** 30-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint-016, Located on Lift 13AE, components between Floor panel FB 3108 to side panel, SEG3007AD, as per WRR no. B –WR-20210. Welder is identified as 200113. ZPMC Quality Control Inspector (QC) is identified as Zhong Yong Hong. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM -Repair.

Flux Cored Arc Welding (FCAW)

Weld joint 004, Located on Lift 13CE components in Deck Panel, SEG3011C. Welder is identified as 066041. ZPMC Quality Control Inspector (QC) is identified as Gong Wei. The welding variables recorded by QC appeared

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to comply with the WPS-B-T-2233-Esab.

Weld joint 009, Located on Lift 13CE components in Deck Panel, SEG3011E. Welder is identified as 052696. ZPMC Quality Control Inspector (QC) is identified as Gong Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Esab.

Weld joint 158, Located on Lift 13BE components in Floor Beam, SEG3009D. Welder is identified as 066881. ZPMC Quality Control Inspector (QC) is identified as Gong Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Esab.

Weld joint 157, Located on Lift 13BE components in Floor Beam, SEG3009F. Welder is identified as 069712. ZPMC Quality Control Inspector (QC) is identified as Gong Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Esab.

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in Bay 19;

Suspender Bracket SB 106E

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

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Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
